

DART AEROSPACE 1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada Tel (613) 632-5200 Fax 613 632-5246		Part No: 650.7401 Part Name: Solenoid Assembly 	
Part Weight: 0 lbs Job Created: 7/24/20 Due Date: 7/31/20 Type: SOLD Note: 6507400 REV.PNC1 JPP REV;A 20.06.23 NEW ISSUE DD VERF JFS		Ship Via:	
Status: Scheduled Job Tracking No: Created By: Jennifer Renwick Description:		Priority: Medium 139 Valve	

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Setup Run Hrs	Standard	Workcenter/Supplier
110	SL-154 - 1	5 pcs	7/30/20		0.25	2.50	Conventional Lathe - 1
							Conventional Lathe - 2
							SL-154 - 1
120	QC 2	5 pcs	7/30/20		0.00	0.00	QC 2 - 1

DART AEROSPACE 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com WWW.dartaerospace.com		Container No: S293144 	
Part: 650.7401 Job No: 211696 Serial No/Batch: S293144 Revision: REV.PNC1 Inspector: Exp Date: Instructions:		Date: 08/10/20	

QC 2 - 1
QC 2 - 12
QC 2 - 14
QC 2 - 17
QC 2 - 19
QC 2 - 2
QC 2 - 20
QC 2 - 22
QC 2 - 23
QC 2 - 25
QC 2 - 32
QC 2 - 33
QC 2 - 35
QC 2 - 39
QC 2 - 4
QC 2 - 40
QC 2 - 44
QC 2 - 45
QC 2 - 48
QC 2 - 49
QC 2 - 50
QC 2 - 51
QC 2 - 52
QC 2 - 57
QC 2 - 62
QC 2 - 63
QC 2 - 8
QC 2 - 66

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PRELIMINARY ISSUE

 650.7401
 Job Sheet 211696


P.T.O.

DAS 62 9-89

DAS 62 9-89

QC 2 - 64					
QC 2 - 65					
QC 2 - 5					
QC 2 - 71					
QC 2 - 73					
QC 2 - 69					
QC 2 - 76					
QC 2 - 86					
QC 2 - 83					
QC 8 - 12	0.00 0.00	7/30/20	5 pcs	130 QC 8	
QC 8 - 14					
QC 8 - 17					
QC 8 - 20					
QC 8 - 25					
QC 8 - 3					
QC 8 - 32					
QC 8 - 33					
QC 8 - 35					
QC 8 - 39					
QC 8 - 4					
QC 8 - 44					
QC 8 - 45					
QC 8 - 49					
QC 8 - 58					
QC 8 - 8					
QC 8 - 9					
QC 8 - 68					
QC 8 - 67					
QC 8 - 1 (A)					
QC 8 - 47					
QC 8 - 40					
QC 8 - 52					
QC 8 - 23					
QC 8 - 57					
QC 8 - 76					
QC 8 - 61					
QC 8 - 66					
QC 8 - 73					
QC 8 - 82					
NV5000 - 1 - B4B	1.00 1.25	7/31/20	5 pcs	140 NV5000 - 1 - B4B	
NV5000 - 2 - B4B					
QC 2 - 1	0.00 0.00	7/31/20	5 pcs	150 QC 2	
QC 2 - 12					
QC 2 - 14					
QC 2 - 17					
QC 2 - 19					
QC 2 - 2					
QC 2 - 20					
QC 2 - 22					
QC 2 - 23					
QC 2 - 25					
QC 2 - 32					
QC 2 - 33					
QC 2 - 35					
QC 2 - 39					
QC 2 - 4					
QC 2 - 40					
QC 2 - 44					
QC 2 - 45					
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PTD For Steps 162, 165 & 168

QC 2 - 48					
QC 2 - 49					
QC 2 - 50					
QC 2 - 51					
QC 2 - 52					
QC 2 - 57					
QC 2 - 62					
QC 2 - 63					
QC 2 - 8					
QC 2 - 66					
QC 2 - 64					
QC 2 - 65					
QC 2 - 5					
QC 2 - 71					
QC 2 - 73					
QC 2 - 69					
QC 2 - 76					
QC 2 - 86					
QC 2 - 83					
QC 8 - 12	0.00 0.00	7/31/20	5 pcs	160 QC 8	
QC 8 - 14					
QC 8 - 17					
QC 8 - 20					
QC 8 - 25					
QC 8 - 3					
QC 8 - 32					
QC 8 - 33					
QC 8 - 35					
QC 8 - 39					
QC 8 - 4					
QC 8 - 44					
QC 8 - 45					
QC 8 - 49					
QC 8 - 58					
QC 8 - 8					
QC 8 - 9					
QC 8 - 68					
QC 8 - 67					
QC 8 - 1 (A)					
QC 8 - 47					
QC 8 - 40					
QC 8 - 52					
QC 8 - 23					
QC 8 - 57					
QC 8 - 76					
QC 8 - 61					
QC 8 - 66					
QC 8 - 73					
QC 8 - 82					
Packaging 3 - 1 - B4B	0.00 0.00	7/31/20	5 pcs	170 Packaging 3-1 - Stock - B4B	
Packaging 3 - 2 - B4B					
Packaging 3 - 3 - B4B					
Packaging 3 - 4 - B4B					
Packaging 3 - 5 - B4B					
Packaging 3 - 6 - B4B					
Packaging 3 - 7 - B4B					
Packaging 3 - 8 - B4B					
Packaging 3 - 9 - B4B					
Packaging 3 - 10 - B4B					
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HLH 20/08/05

J.C. L. 20-08-10

AUG 27 2020

SEP 14 2020

AUG 31 2020

DAS 82 9-89

168 QC 6

QC 6-82

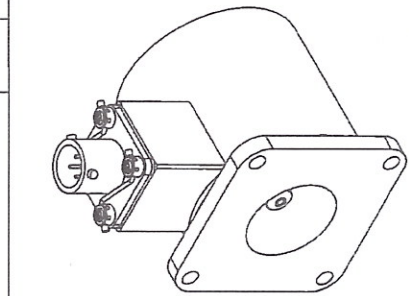
165

180 QC 21 - SA		5 pcs	7/31/20	0.00 0.00	QC 21 - SA - 11 Packaging 3 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B
					QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 9
					QC 21 - SA - 77
					Part Op 110 - ***CRITICAL PART - EXTREME CARE MUST BE TAKEN*** 1- REMOVE PLUNGER FROM SOLENOID 2- Description: MODIFY AS PER DWG AND FOLIO FD335 FOLIO REV: <u>AW</u> DWG REV: <u>PNC2</u> 3-DEBURR *****PLUNGER AND SOLENOID BODY MUST STAY TOGETHER***** 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - ***CRITICAL PART - EXTREME CARE MUST BE TAKEN*** 1-Machine as per folio FD334 ***DO NOT USE COOLANT*** FOLIO REV: <u>AW</u> DWG REV: <u>PNC2</u> 2-Deburr *****ONCE BOTH PART HAVE BEEN MODIFIED, INSERT PLUNGER BACK INTO SOLENOID BODY AND RE-INSTALL PROTECTIVE CAP. SECURE CAP USING TAPE TO MAKE SURE IT DOESN'T FALL OFF. MAKE SURE PART ARE FREE FROM ANY DEBRIS.***** 150 - QC2- Inspect parts off machine FAI/FAIB 160 - QC8- Inspect parts - second check 170 - Identify as per dwg & Stock ***STOCK SOLENOID WITH PLUNGER*** 180 - QC21- Final Inspection - Work Order Release
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
601.3199	Solenoid (L-7747)	5 pcs (1 ea)	110-SL-154 - 1	S287504	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-SL-154 - 1	601.3199	5	5	0	
Part Specifications					
Specifications could not be found.					

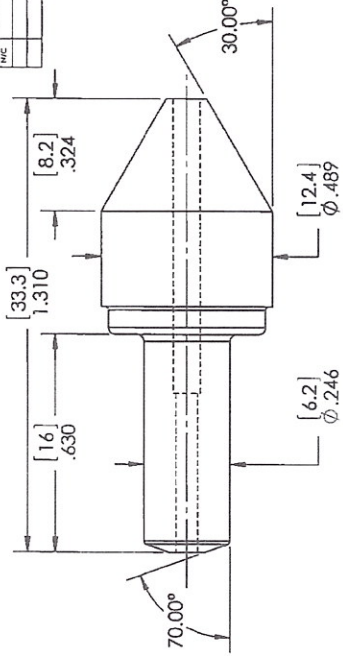
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES, INC. NO PART OF THIS DRAWING IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES, INC.

NOTES

1. VENDOR: GW LISK P/N L-7747
2. ALL METRIC TOLERANCES +/- 0.1 mm



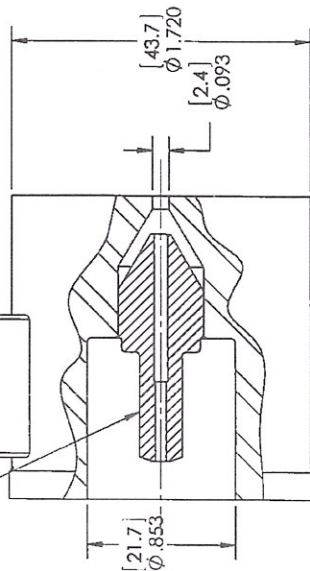
601.3199



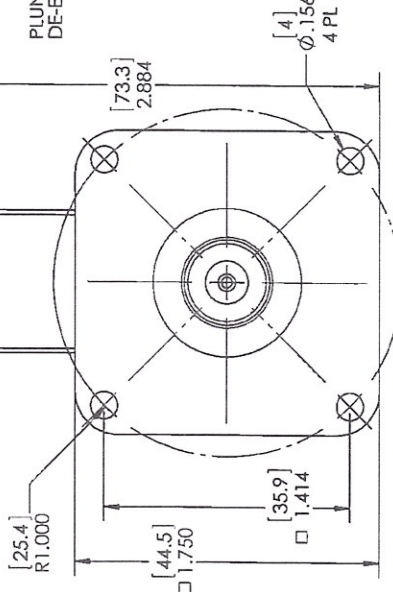
PLUNGER DETAIL



PLUNGER SHOWN IN DE-ENERGIZED POSITION



CONNECTOR MS3112E8-4P



SOURCE CONTROL DRAWING

NOTES:

1. VENDOR: G. W. LISK; VENDOR P/N: L-7747
2. MATERIALS: 400 SERIES STAINLESS STEEL
3. FORCE = 3.0 LB MINIMUM AT .125 IN. STROKE AT 18VDC, AT +70°C (EITHER COIL)
4. STROKE = .125 IN.
5. RESISTANCE = 8 OHM NOMINAL AT +25°C
6. DUTY CYCLE = PULSE
7. DIELECTRIC STRENGTH = 1000 VRMS AT 60 HZ FOR 3-5 SECONDS BETWEEN ALL CURRENT CARRYING PARTS AND GROUND
8. MAX ALLOWABLE LEAKAGE CURRENT = 2.0 mAmps

QTY	PARIS LIST
NEXT ASSY IS	APICAL INDUSTRIES
PREV ASSY IS	2008 TEMPLE HEIGHTS DR.
PREV ASSY IS	OCEANSIDE CA. 92056-3512 1760724-5300
PREV ASSY IS	SOLENOID
PREV ASSY IS	SW P/N: 601.3199
PREV ASSY IS	SCALE: NONE
PREV ASSY IS	SHEET 1 OF 1

REVISIONS		
REV	DESCRIPTION	DATE
N/C	FINAL RELEASE	04-25-2014
		P. BRAVO

Rev	A	Date	14.07.31	Change	New Issue	Revised by	KJ	Approved
Engineering Approval:			(if necessary)			Date:		
Measured by:	ALR		Date:	20/03/20		QC Inspector:	Date:	
Checked by:	J.C.L.		Date:	20/08/10		Date:		
SEP 28 2020 9-89 32 DAS								
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments		
1.740	+0.010 / -0.000	1.749			Mic	0.499268		
0.50 / 0.54	—	0.523			Dial	milling		
0.84 / 0.89	—	0.87			Dial	milling		
0.75	±0.002	0.75			Dial	milling		
0.20	±0.005	0.208			Vern	0.1801739		
0.380	±0.003	0.379			GP	Ref.		
1.00	±0.010	1.00			Vern	0.8017739		
R.125	±0.010	R.125			GP	Ref.		
6.08	±0.05	6.0			Opt. comp.	As per cad		
25.00	±0.5	25.0			"	As per cad		
R.094	±0.010	R.093			GP	Ref.		
0.10	+0.005 / -0.000	0.12			Dial	milling		
0.080	±0.005	0.078			Optical comp.	Ref.		

INSPECTION SHEET

Work Order:	211696
Part Number:	650.7401
Description:	Solevoid Assy
Inspection Dwg:	650.7400
Rev:	PUC2
Page	1 of 1

DART AEROSPACE LTD

DART AEROSPACE LTD

Work Order:	211696
Part Number:	650.7401
Description: SOLENOID ASSEMBLY - PLUNGER	Inspection Dwg: 650.7400
Rev: PNC1	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.275	± .002	1.275	✓		Mic	SB-03
.289	± .005	.291	✓		optical comp	
.232	± .002	.235	✓		Vernier	SB-01 / (Ref)
6-32 UNC - 2B	GO / NO-GO	6-32 UNC 2B	✓		GO / NOGO	6-32 UNC 2B
30.00°	± .5°	30.00°	✓		optical comp	
90.0°	± .5°	90°	✓		optical comp	
.220	+ .005 / - .000	.224	✓		Blade Mic 16 - insp 6	
.098	± .003	.0964	✓		optical comp	
.053	± .003	.0538	✓		optical comp	
PASS-INTED						
OUTROUSS			✓		CORC ATTCH	POMB 046925
nickel platen					CORC ATTCH	POMB 046925
ASTM B733						
(STRAIP PASS.)						

Measured by:	9-89 62 DAS	Checked by:	5.0.0	QC Inspector:	9-89 62 DAS
Date:	20-08-05	Date:	20-08-10	Date:	SEP 29 2020

Engineering Approval:		Date:	
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Rev	A	Date	5-Aug-20	Change	New Issue	Revised by	MG	Approved
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200



PURCHASE ORDER
POHB046925

**Supplier:**

GR0002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention:

Grenon, Sylvie

Ship To:

1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No:

POHB046925

PO Date:

8/18/20

Due Date:

8/26/20

Purchase Order**Revision:****Revision Date:****Issued By:**

Guerin, Kimberley

Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via:

Ground

Pymt Terms:

Net 60

Freight Terms:**Special Comments:**

E-MAILED
2020-08-27

Line	Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	211696	650.7401	650.7400 REV.PNC1		Solenoid Assembly PO: Issue PASSIVATE IAW- 172 section 6.1 *****Plunger only***** Individually wrap plungers and bring to outsource rack Retain solenoid body's in machining department	Firmed -		8/26/20	5 pcs	0 pcs	5 pcs	\$7.6923/pcs	\$38.46
2	211660	654.6410	654.6400 REV-PR2		Fill Port -Issue P/O: PASSIVATE IAW QA-P-35C, TYPE II -Material type: 303 stainless steel -Certificate of Conformity is required	Firmed -		8/26/20	5 pcs	0 pcs	5 pcs	\$7.6923/pcs	\$38.46

AUG 26 2020

AUG 26 2020

DAS
82
9-89

Items

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200



PURCHASE ORDER
POHB046925



Line	Job	Part	Drawing	Description	Status	Account	Due	Order	Received	Balance	Unit	Extended
3	211701	654.6510	654.6500 REV.PR2	Diffuser Cap -4 -Issue P/O; PASSIVATE IAW QQ-P-35C, TYPE II -Material type: 303 stainless steel -Certificate of Conformity is required	Firmed	-	8/26/20	3 pcs	0 pcs	3 pcs	\$7.6923/pcs	\$23.08
AUG 26 2020												
Grand Total: \$100.00												

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)
A022 Apical Processing
A024 process certifications
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents
A048 counterfeit parts avoidance, detection, mitigation and disposition program
A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.



Bon de Livraison / Packing Slip

030356 - 1

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax:

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868

www.groupepattech.com



Date expédition	Créé Par	Generated By	Transport / No de Compte	Bon de commande Client
24-Aug-2020	Ian Wilson			POHBO46925

Line#	No. de Série / # Pièce	Description pièce(s)	CATG.	Comm.	Exp/	Shipped	Qté NC/	Qté scrap/	A venir/
	Job # / Réf #								

1	650.7401	01-PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] PASSIVATION AMIS 2700/QQ-P-35C TYPE II IAW-172 SECTION 6.1 MATERIAL TYPE 303 STAINLESS STEEL	CH	5	5	5	0	0	0
2	654.6410	01-PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] QQ-P-35C, TYPE II MATERIAL TYPE 303 STAINLESS STEEL	CH	5	5	5	0	0	0
3	654.6510	01-PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] QQ-P-35C, TYPE II MATERIAL TYPE 303 STAINLESS STEEL	CH	3	3	3	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Signature

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.

We hereby certify that the parts listed above have been process in accordance with your purchase order and are in conformance with your requirements.

Our financial and legal responsibility will not be higher than the amount of invoice.

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only ☐

Job: <u>211696</u>		DISPOSITION		DEPARTMENT/PROCESS			
Part No. <u>650.7401 (Plunger)</u>		Rework ☒ Scrap ☐ Use-as-is ☐		Skid-tube Machining Large Fab ☐ ☐ ☐ Cross tube Small Fab ☐ ☐ ☐ Finishing ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ Engineering Water Jet Supplier Quality ☐ ☐ ☐ ☐ ☐			
Date: <u>20.09.04</u>	Sequence #: _____	QTY Affected: <u>5</u>		Disposition		MRB (QS1042) 57 DAS 9-8g S/Med/03/07	
Description Work Order Deviation <u>Existing Passivation and Nickel Plate must be removed, from the Plunger only. Once removed, the Plunger must be: Nickel Plated per ASTM Electroless Nickel Plated per ASTM B733 TYPE 4/5 SC 2</u>				This deviation is acceptable Nickel Plating is required in order to prevent rust on bare steel.			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause				FAULT CATEGORY			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☒ Process Improvement ☐ Human Factors ☐				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
Other/Details: _____							

PURCHASE ORDER
POHB047047



Dart Aerospace Ltd.
 1270 Aberdeen St
 Hawkesbury, ON
 K6A 1K7
 Canada
 Tel (613) 632-5200



Supplier:

GRO002-VC
 Group Altech
 2455 Halpern
 St Laurent
 QC
 H4S 1N9 Canada
 Phone: 514-335-3666
 Fax: 514-335-3868
Attention: Grenon, Sylvie
 1270 Aberdeen Street
 Hawkesbury
 ON
 K6A 1K7 Canada
 Phone: 613-632-5200

Ship To:

PO No: POHB047047
PO Date: 9/9/20
Due Date: 9/16/20
Purchase Order
Revision:
Revision Date:
Issued By: Guerin, Kimberley
Phone: 613-632-5200 **Ext:** 298
kguerin@dartaero.com
Via: Ground
Net 60
Pymt Terms:
Freight Terms:
Special Comments:



Line	Job	Part	Drawing	Description	Status	Account	Due	Order	Received	Unit	Extended
1	211696	650.7401	650.7400 REV.PNC1	Solenoid Assembly 1-Strip existing Passivation 2-Electroless Nickel plate per ASTM B733 Type 4/5 SC 2 -Material type: 1215 STEEL -Certificate of Conformity is required	Firmed -		9/16/20	5 pcs	0 pcs	5 pcs	\$24.00/pcs
SEP 14 2020											\$120.00
Grand Total:											\$120.00

68-6
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DAS

X5

SEP 14 2020

Handwritten signature



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

PURCHASE ORDER
POHB047047



Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program
A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Please ensure to send the related invoice to hby_ap@dartaero.com.

Plex 9/11/20 2:47 PM Dart.Guerrin.Kimberley

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: 211696 Part No. 650.7401 (PLUNGER)		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube Machining ☐ Large Fab ☐ Cross tube Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☒			
Date: SEP 14 2020	Sequence #: QC 6	QTY Affected: 5 OR 5	Disposition		68MB8 (QS1042) 15 SVD 5/11/24		
Description Work Order Deviation			Dimensions no longer conform to the drawing. Scrap all 5 plungers. Use 650.7401 Solenoid Assembly as is. Included Plunger replaced with 650.8402 Plunger on the 650.5316 Top level Assy		Completed By DAS 82 SEP 14 2020 9-89 Lead hand / Supervisor		
DURING INSPECTION IT WAS FOUND THAT SURFACE FINISH IS NOT ACCEPTABLE IN THE GROOVE AREA. ALSO PARTS OF THE CHAMFER ARE GONE. Some of the drawing dimensions are not acceptable (see insp.) RETURN TO Y7 ALTECH.			QC / QA Coordinator				
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☒ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☒ Part Lost/Missing ☐ Misread ☐				
Other/Details:							

Rev	A	Date	14.07.31	Change	New Issue	Revised by	KJ	Approved
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Engineering Approval:	(if necessary)	Date:	
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Measured by:	Checked by:	QC Inspector:	Date:
			SEP 14 2020

Drawing	Dimension	Tolerance	Actual	Dimension	Accept	Reject	Method of Inspection	Comments
①	.4884-.4900		.4900		✓		MICRO	66160524
②	1.275	±.002	1.2695		✓	✓	VORN	B18062316
③	.220-.225		0.214		✓	✓	"	"
④	.245-.249		0.246		✓		"	"
⑤	90°				✓			CHARACTER IS NOT PRESENT
⑥	0.625-0.635		.633		✓		VORN	B18062316
⑦	30°		30°		✓			Average FINDER
⑧	6-32 UNC 213				✓			GO GAUGE GOES IN WITH DIFFICULTY
⑨	.289	±.010	.286		✓		VORN	B18062316
⑩	.705-.715		.708		✓			
⑪	CHARACTER IS GONE							
⑫	11							

INSPECTION SHEET

DART AEROSPACE LTD	Work Order:	211696
Description: SOLENOID ASSY. (PUMP)	Part Number:	650.7401 (PUMP)
Inspection Dwg: 650.7400	Rev: PNC I	Page 1 of 1

Mitutoyo
Surtest SJ-400
DATE 2000-01-01
TIME 00:05:23
STAND JIS2001
PROFILE GAUSS
EVA-L 0.16in
N 0.03in
λs 100μin
TILT-COMP. ALL
CURVE-CMP. OFF
M-SPEED 0.02in/s
R-SPEED 0.04in/s
AUTO-RTN ON
RANGE 32000μin
DRIVE ±ESC
STYLUS ON
PRE/POST ON
STAND ON
EVA-L 0.16in
λc 0.03inX5
Rq 10.2μin
Rz 8.1μin
Ra 12.9μin
R-PROFILE
λc=0.03inX5 0.16in
x10K
x50
Ver. 100.000μin/in
Hor. 0.020in/in

Mitutoyo
Surtest SJ-400
DATE 2000-01-01
TIME 00:07:57
STAND JIS2001
PROFILE GAUSS
EVA-L 0.16in
N 0.03in
λs 100μin
TILT-COMP. ALL
CURVE-CMP. OFF
M-SPEED 0.02in/s
R-SPEED 0.04in/s
AUTO-RTN ON
RANGE 32000μin
DRIVE ±ESC
STYLUS ON
PRE/POST ON
STAND ON
EVA-L 0.16in
λc 0.03inX5
Rq 5.7μin
Rz 7.7μin
Ra 60μin
R-PROFILE
λc=0.03inX5 0.16in
x10K
x50
Ver. 100.000μin/in

NCR No.

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only



Job: 211696		DISPOSITION		DEPARTMENT/PROCESS	
Part No. 601.3199 (Solenoid)		Rework ☐ Scrap ☐ Use-as-is ☒		Skid-tube ☐ Machining ☐ Large Fab ☐	
Assembly 650.7401		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	
Date: SEP 24 2020	Sequence #:	QTY Affected: 1	Disposition OF S		
Description Work Order Deviation		Disposition		Completed By: DAS 9-89 20-9-24	
SOLENOID (L-7747) HAS INDENTATION MARKS NEAR THE GROOVE.		indentation will have no impact to the fit, form, or function of the part. acceptable for testing Only		Lead hand / Supervisor: DAS 9-89 20-9-24	
Root Cause		FAULT CATEGORY		QC / QA Coordinator: DAS 9-89 20-9-24	
Operator ☒	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details:				

PURCHASE ORDER
POHB046712



Dart Aerospace Ltd.
 1270 Aberdeen St
 Hawkesbury, ON
 K6A 1K7
 Canada
 Tel (613) 632-5200

**Supplier:**

API001-VU
 Apical Industries
 3030 Entrepise Court Suite A
 Vista, CA 92081-8347 USA
 Phone: 760 509 1615

Ship To:

1270 Aberdeen Street
 Hawkesbury
 ON
 K6A 1K7 Canada
 Phone: 613-632-5200

PO No:

POHB046712

PO Date:

7/9/20

Due Date:

7/16/20

Purchase Order

Revision:

Revision Date:**Issued By:**

Guerin, Kimberley

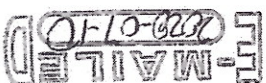
Phone: 613-632-5200 Ext: 298

kguerin@dartaero.com

Fedex P1 Overnight

Net 30

Collect

Via:**Pynt Terms:****Freight Terms:****Special Comments:**

Line	Item	Job	Part	Drawing	Description	Status	Account	Due	Order	Received	Balance	Unit	Extended
1					Solenoid (L-7747)	Firmed -		7/16/20	5 Ea	0 Ea	5 Ea	\$697.1415/Ea	\$3,485.71

Line Item Note: Inter-Company transfer

PLEASE INCLUDE CERTS

Grand Total: \$3,485.71

Order Notes

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Procurement Quality Clauses

A034 INTER COMPANY SHIPPERS

Plex 7/10/20 1:31 PM Dart.Guerin.Kimberley

Dart Aerospace Ltd.
3030 Enterprise Court, Suite A
Vista, CA 92081-8347
Tel (760) 724-5300
Fax (760) 509-1562



Customer Shipper

Shipper No: 05458



Invoice No: V10004969

Ship Date: 7/10/20

Shipping Tracking No: 176677848733

Freight Terms: PrePaid

INCO Terms: Ex Works

FOB: Shipping Point

Ship To: DART Aerospace Ltd
1270 Aberdeen Street
Hawkesbury ON K6A 1K7
Canada
Bill To: DART Aerospace Ltd
1270 Aberdeen Street
Hawkesbury ON K6A 1K7
Canada
Contact: Guerin, Kimberley
Phone:

FEDEX P1 OVERNIGHT

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER,
(DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS
APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT
A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION,
MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS
Procurement Quality Clauses
A034 INTER COMPANY SHIPPERS

Order No	Cust PO	Customer Order Line No	Rel	Part No	Part Name	Serial No/Batch	Ship Units	Ship Qty	Net	Gross
27770	POH046712	1	601.3199	Solenoid (L-7747)	s/n 0619-0627 (1)		1	5	11 lbs	11 lbs
Shipping										
Total:										
								5	11 lbs	11 lbs
								YTD: 5	11 lbs	11 lbs

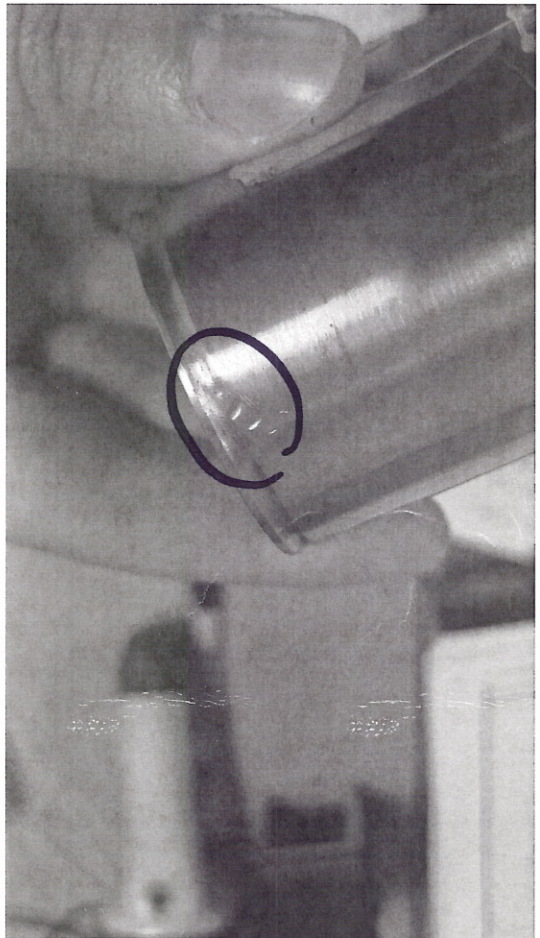
Plex 7/10/20 12:54 PM Dart, Everette, Jean Page 1

RECEIVED

JUL 13 2020

DART AEROSPACE LTD.

1-Bot
Fax: 1766-7784-8733



Ketan Tailor

From: Tyler Cross
Sent: September-24-20 3:21 PM
To: Ketan Tailor
Cc: Steven Drouin
Subject: RE: Deviation for 650.7401 Solenoid Assembly

Im fine with this marks for the qual testing valves. They should have no effect on the caps installation and function.
Do we know what caused this? Is this something we can correct.?

Tyler

From: Ketan Tailor <ktailor@dartaero.com>
Sent: Thursday, September 24, 2020 7:12 AM
To: Tyler Cross <tcross@dartaero.com>
Cc: Steven Drouin <sdrouin@dartaero.com>
Subject: Deviation for 650.7401 Solenoid Assembly

Hey Tyler,

We have one Solenoid which has some indentation around the groove where the Cap and Cap Retainer would sit.
Please see the attached pictures.
Is it acceptable to use as is?

Thanks,
Ketan



Dart Aerospace Ltd.
3030 Enterprise Court, Suite A
Vista, CA 92081-8347
Tel (760) 724-5300
Fax (760) 509-1562

Certificate of Conformance

Date: 7/10/2020
Certification To: DART Aerospace Ltd
1270 Aberdeen Street
Hawkesbury ON K6A 1K7
Canada

PART INFO

"This is to certify that the items identified herein have been manufactured, assembled, inspected and/or tested in accordance with all Apical Industries, Inc. dba Dart Aerospace applicable specifications, drawings and other purchase order requirements."

Customer Part No: 601.3199

Part Name: Solenoid (L-7747)

Quantity: 5

Container No(s): VT171972

Serial No/Batch(s): s/n 0619-0627

Dart Vista Part No: 601.3199

Shipper No: 05458

Revision:

Customer Part Rev Level:

Customer PO No: POHB046712

Remit to: DART Aerospace Ltd., 1270 Aberdeen Street, Hawkesbury, Ontario K6A 1K7 Canada

Tel: 613 632 5200

Fax: 613 632 5246

accounting@dartaero.com

GST/HST 10127 2607

Note: A minimum 15% restocking fee is applicable. Custom items are non-refundable. Full warranty details are available at www.dartaerospace.com

Signature

Date

7/10/2020

1. Approving Civil Aviation
Authority/Country:
FAA/UNITED STATES

2. **AUTHORIZED RELEASE CERTIFICATE**
FAA Form 8130-3, AIRWORTHINESS APPROVAL TAG

3. Form Tracking Number:
2020-07-10-0006

4. Organization Name and Address:
Apical Industries, Inc. dba Dart Aerospace
3030 Enterprise Court, Suite A
Vista, CA 92081-8347
Phone: (760) 724-5300

PQ1886NM

5. Work Order/Contract/Invoice Number:

Shipper No: 05458
Order No: 27770
Cust PO: POHB046712

6. Item:	7. Description:	8. Part Number:	9. Quantity:	10. Serial Number:	11. Status/Work:
1.	Solenoid (L-7747)	601.3199	5.00000	0619, 0620, 0621, 0622, 0627	New

12. Remarks: Item 1 is a subcomponent of a FAA PMA article.

13a. Certifies the items identified above were manufactured in conformity to:

- ☒ Approved design data and are in a condition for safe operation.
☐ Non-approved design data specified in Block 12.

14a. ☐ 14 CFR 43.9 Return to Service ☐ Other regulation specified in Block 12
Certifies that unless otherwise specified in block 12, the work identified in Block 11 and described in Block 12 was accomplished in accordance with Title 14, Code of Federal Regulations, part 43 and in respect to that work, the items are approved for return to service

13b. Authorized Signature: 	13c. Approved/Authorization No.: PQ1886NM	14b. Authorized Signature:	14c. Approval/Certificate No.:
13d. Name (Typed or Printed): Gordon Law	13e. Date (dd/mm/yyyy): 10/Jul/2020	14d. Name (Typed or Printed):	14e. Date (dd/mm/yyyy):

User/Installer Responsibilities

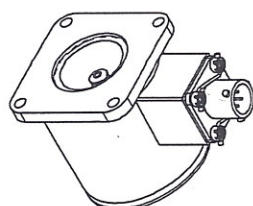
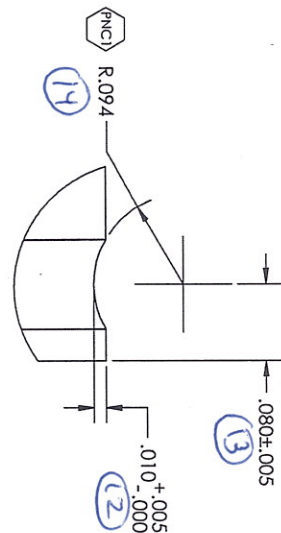
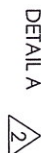
It is important to understand that the existence of this document alone does not automatically constitute authority to install the aircraft engine/propeller/article.

Where the user/installer performs work in accordance with the national regulations of an airworthiness authority different than the airworthiness authority of the country specified in Block 1, it is essential that the user/installer ensures that his/her airworthiness authority accepts aircraft engine(s)/propeller(s)/articles(s) from the airworthiness authority of the country specified in Block 1.

Statements in Blocks 13a and 14a do not constitute installation certification. In all cases, aircraft maintenance records must contain an installation certification issued in accordance with the national regulations by the user/installer before the aircraft may be flown.

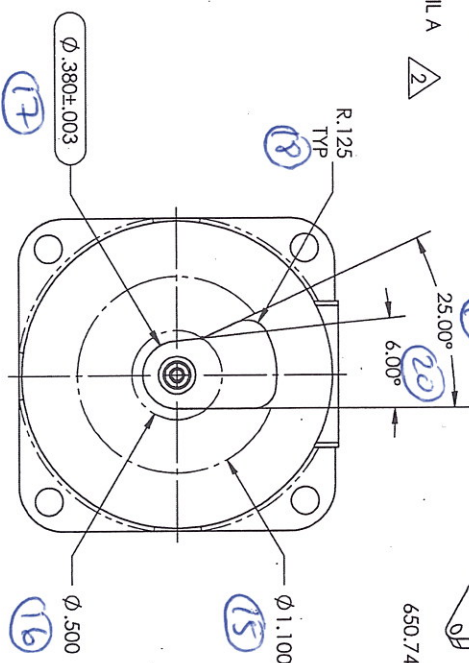
NOTES

- PLUNGER SHOWN IN
DE-ENERGIZED POSITION



REVISIONS		
REV.	DESCRIPTION	DATE
N/C	PIHIA, RELEASE	04-25-2014
		P. BRAVO

SECTION B-B



PROTOTYPE REVISIONS					
D	ZONE	REV	DESCRIPTION	DATE	APPROVED
	A-4.1		DIMENSION WAS 8.100 IS 8.094		
	B-5.1		ADDED .084-.089 DIMENSION AND SURFACE ROUGHNESS VALUE		
	C-1		DIMENSION WAS Ø .961 IS Ø .1026		
	C-2.1		DIMENSION WAS Ø .853 IS (Ø .8520-.85359)		
	PNC1		DIMENSION WAS .063 IS .059-.054	06/01/2020	
			ADDED SURFACE ROUGHNESS VALUE		
			ADDED SURFACE ROUGHNESS VALUE		
			ADDED SURFACE ROUGHNESS VALUE		
			ADDED FLAG NOTE 2 TO SECTION B-B		
	C3.1				
	C7.1				
					T. CROSS ✓

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 211696

1	1	60.3199	SOLÉNOID		
X		650.7401	SOLÉNOID ASSEMBLY		
7401	FINO	PART NO.	DESCRIPTION	MAT'L	SPFC
PARTS LIST					
APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300					
QTY	ORIGINAL PART	DESCRIPTION			
NEXT ASSY (S)	60-3524	SOLENOID			
650.5500	NICH	1.8000			
	PLATING MATERIAL				
	CONTRACT NO.	06-35-01			
UNITS SHOWN FACED TOLERANCES ARE IN 1 PLACES UNLESS NOTED ANGLES 5:30					
DR. CODE CODE DWR. NO. 650.7400		REV.			
8.0000 SCALE NONE		SHEET 1 OF 2			
SOLÉNOID ASSEMBLY					

Engineering Approval: (if necessary)		Date:	
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Measured by:	Checked by:	QC Inspector:	Date:

[illegible]

DART AEROSPACE LTD		Work Order:	211696
Description:		Part Number:	650.7401 <i>0620</i>
Inspection Dwg: 650.7400		Rev: PNC1	Page 1 of 1

Rev	A	Date	14.07.31	Change	New Issue	Revised by	KJ	Approved
Engineering Approval:				(if necessary)		Date:		
Measured by:				Checked by:	QC Inspector:		Date:	
32 DAS SFP 28 2020 89								
Drawing	Dimension	Tolerance	Actual	Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.026		+/- .005	1.025		✓		VERN	B18062316
Ø.8535-.8520			.8525		✓		Inside Micrometer 896032	
.089-.084			.086		✓		Height Gage	31007
.054-.050			.052		✓		Height Gage	31007
R.015-.005			.010		✓		RAD GAGE	
1.740 MIN			1.474		✓		Height Gage	31007
.075		+/- .002	.075		✓		Height Gage	31007
.209		+/- .005	.209		✓		VERN	B18062316
16			10.2 Ra		✓		Surface roughness tester	
16			5.7 Ra		✓		Surface roughness tester	
63							Surface roughness comparator	
.010		+ .005 - .000	.012		✓		OPTICAL COMPARATOR	
.080		+/- .005	.081		✓		OPTICAL COMPARATOR	
R.094		+/- .005	R.098		✓		RAD GAGE 2.5mm (.098 in.)	
Ø1.100		+/- .005	1.099		✓		VERN	B18062316
Ø0.500		+/- .005	.500		✓		VERN	B18062316
Ø0.380		+/- .003	.379		✓		GAGE PIN	Ø0.379
R.125		+/- .005	R.125		✓		GAGE PIN	Ø0.250
25 deg		+/- .5 deg	24.95		✓		vern	62671113
6 deg		+/- .5 deg	6.02		✓			

INSPECTION SHEET

DART AEROSPACE LTD		Work Order:	211696
Description:		Part Number:	650.7401
SOLENOID ASSEMBLY			-0622
Rev: PNC1		Page 1 of 1	
Inspection Dwg: 650.7400			

Rev	A	Date	14.07.31	Change	New Issue	Revised by	KJ	Approved
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Engineering Approval:			Date:			Date:		
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Measured by:	Checked by:	QC Inspector:	Date:	SEP 28 2020	Date:
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Drawing	Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.026		+/- .005	1.025	✓		VERN	B18062316
Ø.8535-.8520			.8525	✓		Inside Micrometer 896032	
.089-.084			.086	✓		Height Gage	31007
.054-.050			.052	✓		Height Gage	31007
R.015-.005			.010	✓		RAD GAGE	
1.740 MIN			1.474	✓		Height Gage	31007
.075		+/- .002	.075	✓		Height Gage	31007
.209		+/- .005	.209	✓		VERN	B18062316
16			10.2 Ra	✓		Surface roughness tester	
16			5.7 Ra	✓		Surface roughness tester	
63				✓		Surface roughness comparator	
.010		+ .005 -.000	.012	✓		OPTICAL COMPARATOR	
.080		+/- .005	.081	✓		OPTICAL COMPARATOR	
R.094		+/- .005	R.098	✓		RAD GAGE 2.5mm (.098 in.)	
Ø1.100		+/- .005	1.099	✓		VERN	B18062316
Ø0.500		+/- .005	.500	✓		VERN	B18062316
Ø0.380		+/- .003	.379	✓		GAGE PIN	Ø0.379
R.125		+/- .005	R.125	✓		GAGE PIN	Ø0.250
25 deg		+/- .5 deg	24.95	✓		vern	62671113
6 deg		+/- .5 deg	6.02	✓			

INSPECTION SHEET

DART AEROSPACE LTD	Work Order:	211696
Description:	SOLENOID ASSEMBLY	Part Number:
Inspection Dwg:	650.7400	Rev: PNC1
Page 1 of 1		

DART AEROSPACE LTD		Work Order:	211696
		Part Number:	650.7401
Description:		SOLENOID ASSEMBLY	
Rev: PNC1			
Inspection Dwg: 650.7400		Page 1 of 1	

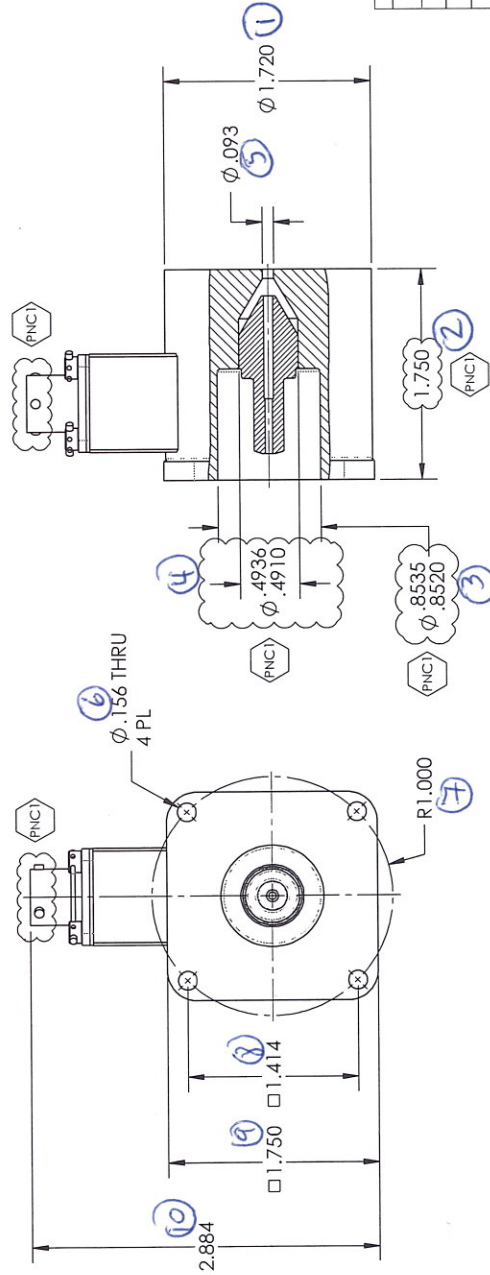
DART AEROSPACE LTD		Work Order:	211696
		Part Number:	650.7401
Description:		SOLENOID ASSEMBLY	
Rev: PNC1			
Inspection Dwg: 650.7400		Page 1 of 1	

INSPECTION SHEET

DART AEROSPACE LTD		Work Order:	211696
Description:		SOLENOID ASSEMBLY	Part Number:
			650.7401
			-0627
Inspection Dwg: 650.7400		Rev: PNC1	Page 1 of 1

1. SOLENOID MATERIAL: 400 SERIES STAINLESS STEEL
2. FORCE: 3.0 LBS MINIMUM AT .125 STROKE, AT 18VDC, AT +70°C (EITHER COIL)
3. STROKE: .125
4. RESISTANCE: 8 OHMS NOMINAL AT +25°C
5. DUTY CYCLE: PULSE
6. DIELECTRIC STRENGTH: 1000 VRMS AT 60 HZ FOR 3-5 SECONDS BETWEEN ALL CURRENT CARRYING PARTS AND GROUND.
7. MAXIMUM ALLOWABLE LEAKAGE CURRENT: 2.0 mAmps
8. CONNECTOR: MS3112E8-4P
9. SUGGESTED VENDOR: LISK
10. SUGGESTED VENDOR P/N: L-77147

DISCARD PLUNGER INCLUDED WITH SOLENOID



PARTS LIST

[illegible]

Rev	A	Date	14.07.31	Change	New Issue	Revised by	KJ	Approved
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Engineering Approval:	(if necessary)	Date:
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Measured by:	Date:	Checked by:	Date:	QC Inspector:	Date:
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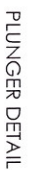
Drawing	Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1	Ø 1.720	+/- .005	Ø 1.723	✓		VERN	B18062316
2	1.750	+/- .005	1.749	✓			
3	Ø.8535-Ø.8520		Ø.8525	✓			
4	Ø.4936-Ø.4910		.492	✓		GAGE PIN Ø.492	
5	Ø.093	+/- .005	Ø.207	✓	✓	VERN	B18062316
6	Ø.156 THRU	+/- .005	Ø.154	✓			
7	R1.000	+/- .005	R1.001	✓			
8	1.414	+/- .005	1.411	✓			
9	1.750	+/- .005	1.750	✓			
10	2.884	+/- .005	2.885	✓			

INSPECTION SHEET

DART AEROSPACE LTD	Work Order:	211696
Description:	SOLENOID	Part Number:
601.3199		
Inspection Dwg:	601.3199	Rev: PNC1

* ENLARGE TO Ø.209
S/N 211696 OR 110 (PNC1)

THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR OCEANSIDE, CA 92056-5312 (760) 724-5300		SOLENOID ASSEMBLY	
ORIGINAL DATE DRAWN BY H.C.M. CHECKED BY P. BRAND DRAWING APPROVAL DATE: 11/1/83 CONTRACT NO.	NEXT ASSY IS 650.5300	USED OTHERS VICTOR DIMENSIONS ARE IN INCHES 3/4 PLACES 1/8 IN. 3/4 PLACES 1/8 IN. ANGLES ± 3°	REV P/AC DWG. NO. 650.7400 B. 0/NAZ SCALE NONE SHEET 2 OF 2



62641113

0619, 0627, 0622
0621, 0623

Part Number: 650.7401	Rev: PCN2
Description: SOLENOID ASSEMBLY	Inspection Dwg: 650.7400
Work Order:	
- Page 1 -	

Element name	Nominal	UpperTol	LowerTol	Actual	Deviation	TolBar
Plane		0.0010		0.0003	0.0003	
25 DEG	25.0000	0.5000	-0.5000	24.9525	-0.0475	-----
6 DEG	6.0000	0.5000	-0.5000	6.0271	0.0271	*****
0.380	0.3800	0.0030	-0.0030	0.3795	-0.0005	-----
.125	0.1250	0.0050	-0.0050	0.1243	-0.0007	-----
.125	0.1250	0.0050	-0.0050	0.1245	-0.0005	-----
1.100	0.5500	0.0050	-0.0050	0.5454	-0.0046	-----

Measured by:	Audited by:	Preliminary Approval:
Date:	Date:	Date:
2020-9-28		